



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G00632-3G

Job Sheet 191020



Part No: RBW6205G00632-3G

Job Qty: 2 pcs

Part Name: Sling, Main Rotor Blade Lift



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 5/9/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	5/9/19	5/9/19	0.00	0.00	Purchasing - 1		MAY 09 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	5/9/19	5/9/19	0.00	0.00	Packaging 2 - 1 - B4B		MAY 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		

Plex 5/9/19 1:04 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S179684



Part: RBW6205G00632-3G

Job No: 191020

Serial No/Batch: S179684

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 05/09/19

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	5/9/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
121 Small Fab - 2 - B4B	2 pcs	5/9/19	0.00 4.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
122 QC 5	2 pcs	5/9/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	2 pcs	5/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
			140 QC 21 - FG	QC 21 - FG - 21	0-25
				QC 21 - FG - 70	21
				QC 21 - FG - 53	0-25

AUG 30 2019

GA-TBD

Part Op 100 - Issue P/O: _____ MANUFACTURE RBW6205G00632-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required
110 - (Receive & Inspect for Damage & Mat'l Certs
120 - (QC6- All purchased or subcontracted products)
121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3- Engrave RB41011 placard. 4-Transfer drill placard as per DWG. 5-Using #2 drive screws install placard 6-Apply sticker as per DWG.
122 - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	2 pcs (1 ea)	100-Purchasing	5179683
90081A074	0.125 X 0.500 #2 Drive Screw	8 Ea (4 ea)	121-Small Fab - 2 - B4B	5122133
RB41011	Dart Tooling Placard, Aluminum	2 pcs (1 ea)	121-Small Fab - 2 - B4B	5021040
RBW6205G00632-3G-77	Sticker	2 pcs (1 ea)	121-Small Fab - 2 - B4B	5142773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00632-3GP	2	0	0
121-Small Fab - 2 - B4B	90081A074	8	139	0
	RB41011	2	335	0
	RBW6205G00632-3G-77	2	5	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Canada

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RBW6205G00632-3G

Job Sheet 191020



Part No: RBW6205G00632-3G

Job Qty: 1 ea

Part Name: Sling, Main Rotor Blade Lift



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 4/24/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G00632-3G Rev 6 IPP Rev A 18.01.11 New issue-DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		4/24/19	0.00	0.00	Purchasing		
110	Packaging	1 pcs		4/24/19	0.00	0.00	Packaging2		
120	QC	1 pcs		4/24/19	0.00	0.00	QC6		
121	Small Fab	1 pcs		4/24/19	0.00	2.00	Small Fab-5		
122	QC	1 pcs		4/24/19	0.00	0.00	QC5		
130	Packaging	1 pcs		4/24/19	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		4/24/19	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 05/09/2019

MANUFACTURE RBW6205G00632-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

121 - PERFORM FIRST ARTICLE WEIGHT TEST 1. AFTER INSPECTION, PLACE 300 LBS. IN M/R BLADE LIFTING TOOL. LIFT M/R BLADE LIFTING TOOL USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION. 2- REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS. Fill out inspection sheet. (sheet 47). 3- Engrave RB41011 placard. 4-Transfer drill placard as per DWG. 5-Using #2 drive screws install placard 6-Applly sticker as per DWG.

rc Rhus 20 Feb 2019.

Job BOM

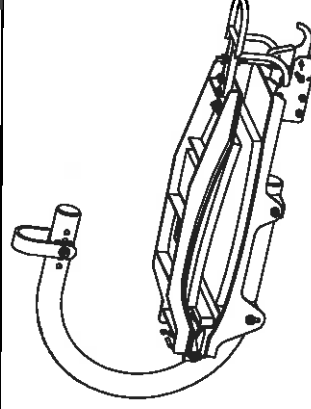
Part / Item	Component Name	Quantity	Operation	Container
RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	1 pcs (1 ea)	100-Purchasing	
90081A074	0.125 X 0.500 #2 Drive Screw	4 Ea (4 ea)	121-Small Fab	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab	
RBW6205G00632-3G-77	Sticker	1 pcs (1 ea)	121-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G00632-3GP	1	0	0
121-Small Fab	90081A074	4	143	0
	RB41011	1	409	0
	RBW6205G00632-3G-77	1	5	0

Part Specifications
Specifications could not be found.

Plex 2/20/19 2:43 PM dart.Lussier.Patrick



DART
AIRSPACE

TITLE	TOOL, M/R BLADE LIFTING		DWG NO.	RBW6205G00632-3G		REV	6
DATE			UNLESS OTHERWISE SPECIFIED				
SCALE			ALL DIMENSIONS ARE IN INCHES				
1/8"			FRACTIONS ARE TO BE USED				
			DECIMALS ARE TO BE USED				
			TOLERANCES ARE				
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DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO042669



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042669
PO Date: 2/20/19
Due Date: 5/9/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191014	RBW6005G00131-3GP			Multi-Purpose Trolley REV 5	Firmed	-	5/9/19	1 pcs	0 pcs	1 pcs	\$3,205.00/pcs	\$3,205.00
2	191020	RBW6205G00632-3GP			Sling, Main Rotor Blade Lift As per Dwg RBW6205G00632-3G Rev. 6	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$5,980.00/pcs	\$11,960.00
3	191016	RBW6205G09031-3GP			Main Rotor Head Support - Trolley Adapter REV 3	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$1,430.00/pcs	\$2,860.00
4	191019	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	5/9/19	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Grand Total:													\$18,325.00

	Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200	PURCHASE ORDER PO042669 
Order Notes		
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation. Procurement Quality Clauses - A005 RIGHT OF ENTRY - A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER) - A012 CHEMICAL AND PHYSICAL TEST REPORTS - A016 PERSONNEL QUALIFICATION - A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) - A026 CERTIFICATION OF MATERIAL CONFORMANCE - A041 QUALITY MANAGEMENT SYSTEM - A042 DART NOTIFICATION BY SUPPLIER - A043 RETENTION OF QUALITY DOCUMENT - A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM - A049 SUPPLIER AWARENESS 		

Plex 5/9/19 11:20 AM dart.Lussier.Patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill To: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship To: Att. Patrick Lussier
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No:	25187	Customer Code:	DART
Shipment Date:	08-May-2019	Phone:	(613) 632-9577
Ship Via:	Pick up at METEC	PO Number:	PO042669 ✓
Order Number:	3520		
Order Date:	02/20/19	Terms:	Net 60 Days

----- Quantity -----								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
2	2	2 ✓	0	0	EA	RBW6205G00632-3GP Sling, Main Rotor Blade Lift	6	3520-02

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RECEIVED
MAY 09 2019
DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO: same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2	RBW6205G00632-3GP	Sling, Main Rotor Blade Lift	6	42669

MATERIAL: supplied by METEC

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We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Theoret

Vankleek Hill, May 8, 2019



LOAD TEST PROTOCOL

Title : Sling, Main Rotor Blade Lift

DWG : RBW6205000632 -3G Rev : 6

Part # : _____ Serial # : _____

Date : May 8 /2019 Inspector : George Theoret

Inspection Method : Load Tester Qty. 2

As per Client Protocol: ☒

Protocol Attached : ☐

Load Requirement : lbs 300 kg _____

Load Weight for 5 minutes

Pre Inspection Deflection ☐ Distortion ☐ Cracking ☐ Tearing ☐ Others ☐

Description: _____

Under Load Inspection Deflection ☐ Distortion ☐ Cracking ☐ Tearing ☐ Others ☐

Description: _____



Post Inspection

Deflection ☐ Distortion ☐ Cracking ☐ Tearing ☐ Others ☐

Description: _____

Pictures : Yes ☒ No ☐

Pictures Attached
to Protocol : Yes ☐ No ☐

Load Test Result : Pass ☒ Fail ☐

If Fail Describe : _____

Inspector: George Theoret

Signature: George Theoret DAS
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9-89

Tester : _____

Signature : _____

S/N : _____

Date : May 6 / 2019



